



Dart Aerospace Ltd.
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10584
NOV 15

C45-3-6

Job Sheet 185265



Part No: C45-3-6

Job Qty: 4 ea 10

DAS
21
9-89

Part Name: Latch



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-3-6 rev.10 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-4		J.C.L.
100	Bandsaw	4 pcs	11/9/18	11/9/18	0.00	0.20	Bandsaw1		J.C.L. 18-11-04
120	CNC Vertical Machining	4 pcs	11/9/18	11/9/18	0.50	2.00	MORI NV5000-1		J.C.L.
130	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-5		J.C.L. 18-11-04
140	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-5		J.C.L. 18-11-05
150	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2		J.C.L.
160	QC21-FG	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		J.C.L.

Part Op 100 - CUT BLANK AT 1.825"

Descriptions: 120 - 1-Machine as per folio FB814 FOLIO REV: AA DWG REV: 10 2-Deburr

130 - 1-Engrave Batch number as required Using Marktronic engraver as per DWG.

150 - Identify and Stock

9-89

NOV 07 2018

GA206

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	.6666 ft (.16666 ea)	90-Start up Operation	SO 88 987

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	1	16	0

Part Specifications

Specifications could not be found.



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Plex 10/24/18 11:42 AM Dart.lajeunesse.marie

Container No: S123057



Part: C45-3-6

Job No: 185265

Serial No/Batch: S123057

Revision: 10

Inspector:

Exp Date:

Instructions:

Date: 10/31/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

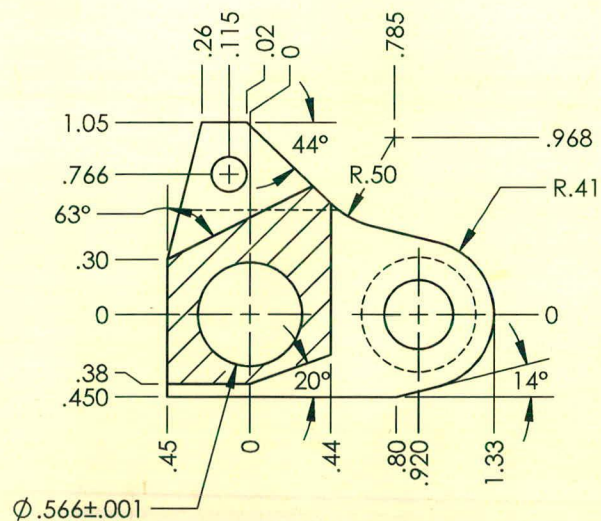
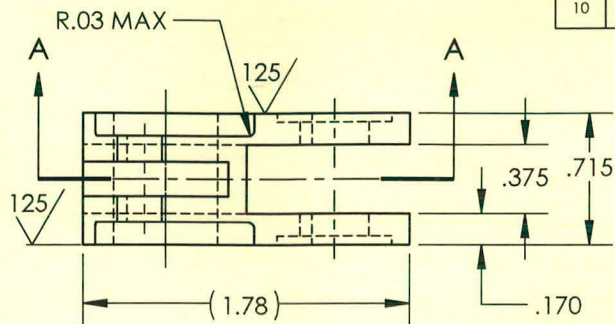
QA Closed: _____ Date: _____

Work Order update only ☐

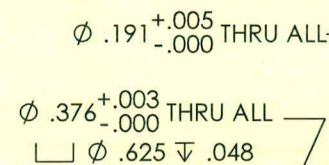
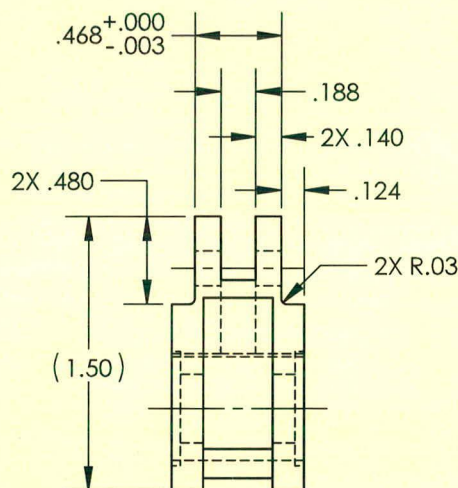
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
8		AS DRAWN BY CANAM.	9/11/2012	RJC
9		CH'D Ø.564 TO Ø.566 & Ø.189 TO Ø.191	10/30/2012	JAG
10	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD
				RW



SECTION A-A



SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 185265 MWS
18-10-24

NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LATCH	
DWG NO. C45-3-6	REV 10
MAT'L 17-4 SS	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 5/14/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-6	1	LATCH	17-4 SS	3/4 X 1-1/2 X 2

